

45

Date: Thursday, 10/25/2007 10:12:24 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER BLOCK
Job Number : 35365A	
Estimate Number : 10251	
P.O. Number :	Part Number : D3193041
This Issue : 10/25/2007 S.O. No. :	Drawing Number : D3193 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / 1 Type : LANDING GEAR	Drawing Revision : C
Previous Run : 32569A	Material :
Written By :	Due Date : 11/5/2007 Qty: 8 Um: Each
Checked & Approved By : <u>10/07.10 25</u>	
Comment : Est Rev:A New Issue 05-11-05 JLM	
Est Rev:B Change Rivet Length 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2500X03500	6061-T6 Bar 2.5" x 3.5"
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Comment: Qty.: 0.5156 f(s)/Unit Total : 4.1244 f(s)

Material: 6061-T6/T651 (QQ-A-225/8 or QQ-A-200/8)

(M6061T6B2.500x03.500)

M102838X3

Identify for D3193-1

Batch: M9657X5

MK 08/02/12

⑧

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 3.500" x 2.500" x 5.900" long Bar

MK 08/02/12

⑧

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1

2-Deburr and Tumble

MK 08/02/12

⑧

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MK 08/02/12

⑧

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MK 08-02-12

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(8)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-02-13

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Fd 08/02/14 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-14 (X8)

9.0

MS20426AD37

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 MS20426AD3-7

Rivet

M17694

MF

10.0

MS21073L4

NUTPLATE



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21073L4

Nut Plate

M102254

MF 08-02-22

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3193-041 as per Dwg D3193

MF 08-02-22 (8)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-02-25 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 08/02/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER BLOCK

Job Number: 35365A

Part Number: D3193041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/26

Job Completion



Packing

473

8/2/25

(8)

80

2008/2/25

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

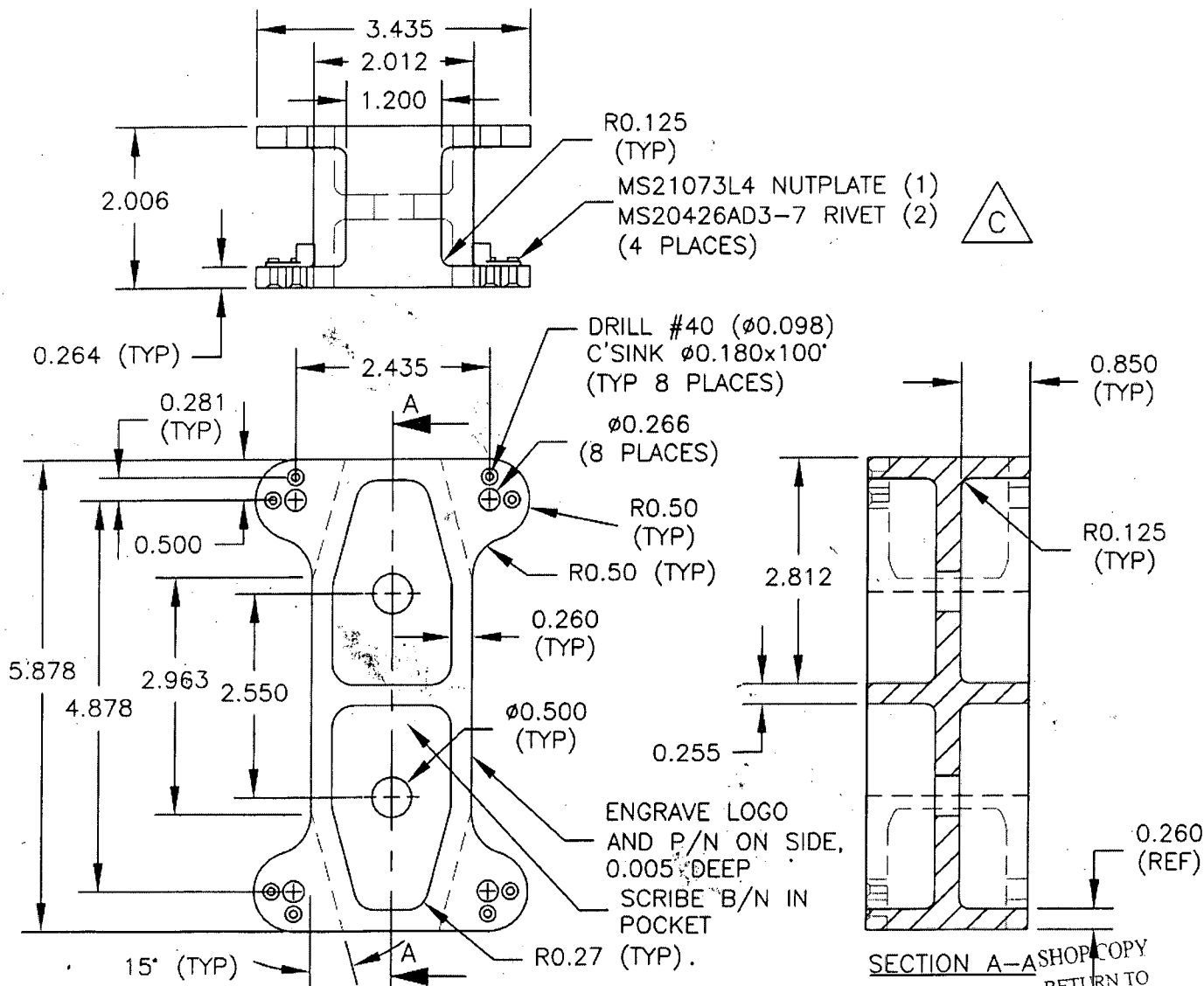
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3193	REV. C SHEET 1 OF 1
DATE 05.09.29		TITLE SUPPORT BRACKET ASSEMBLY	SCALE 1:2
A	03.06.09	NEW ISSUE	
B	03.12.22	MANUFACTURED BY DART	
C	05.09.29	MS20426AD3-7 WAS MS20426AD3-5	

RELEASED
05.09.30



D3193-041 SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET)

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 35365A

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DART AEROSPACE LTD		Work Order: 35365A
Description: SUPPORT BRACKET	Part Number: 03193-1	
Inspection Dwg: 03193 Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.435	± 0.010	3.436	—			
2.012	± 0.010	2.013	—			
1.200	± 0.010	1.200	—			
2.006	± 0.010	2.003	—			
R0.125	± 0.010	R.125	—			
2.435	± 0.005	2.433	—			
0.281	± 0.005	0.283	—			
0.264	± 0.010	0.260	—			
5.878	± 0.010	5.880	—			
4.878	± 0.005	4.877	—			
2.550	± 0.010	2.549	—			
15°	$\pm 1/2^\circ$	15°	—			
0.260	± 0.010	0.263	—			
R0.50	± 0.030	R.500	—			
Ø0.266	± 0.001	Ø0.272	—			
Ø0.098	± 0.001	Ø0.102	—			
Ø.180 X 100°	± 0.001	Ø.182 X 100°	—			
0.850	± 0.010	0.857	—			
R0.125	± 0.010	R.125	—			
0.255	± 0.010	0.254	—			
2.812	± 0.010	2.812	—			

Measured by: <i>[Signature]</i>
Date: 08/02/12

Audited by: <i>[Signature]</i>
Date: 08-02-12

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

1/0 03193-041

[Signature]